

Work Order ID 75903

75903

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November-01-11 2:24:22 PM

Item ID: D412-742-013

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Float Skidtube Installation

Start Date: 01/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 15/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 11/11/01

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

DSI 9517

B

IIN D412-742

D

100

0.00

100

DOCUMENT CONTROL

xsp

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-742-013

CHG006

CHG007

4/11/08

8/12/11

MLJ 12-1-3

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

12/1/2

1375907

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 75903***75903***

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Item ID: D412-742-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Float Skidtube Installation

Start Date: 01/11/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 15/11/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									
130		0.00							
130	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D412-742-013								
	Location: <u>73</u>								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

MF
12-01-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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75903

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev: A05.10.13 New Issue KJ/JLM
 IPP Rev: B 06-06-08 As per DSI9336 JLM IPP RevC 07-12-03 ECN 1072 DD verified by: JLM
 IPP Rev: D 08-09-08 ecn 08-510 DD verified by: EC
 IPP Rev: E 09-01-23 as per DSI9441 DD verified by: EC IPP RevF: add AN4C7A DD 10.01.13 verified by: EC
 IPP Rev: G 11.11.01 as per DSI9517 REV.B DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4C53A *AN4C53A* Bolt		Purchased	No			110	Each	21.0000	4	4			
										**	11/11/11 11:16:58 M119688		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST361		21							
				115723		10							
				119447		11							
AN4C7A *AN4C7A* Bolt		Purchased	No			110	Each	315.0000	4	4			
										**	11/11/11 11:16:58 M119688		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST356		315							
				109147		315							
D3403-5 *D3403-5* Bushing		Manufactured	No			110	Each	108.0000	8	8			
										**	12/1/12 11:16:58 M119688		
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				FG052		100							
				74761		100							
				ST361		8							
				66530		8							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 75903

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Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

D412-742-043

Manufactured No

110 Each

0.0000

1

1

D412-742-043

Replacement Float Skidtube

D2571

Manufactured No

110 Each

3.0000

1

1

D2571

Saddle, Fwd Out 205

**

**

B75903 12/11/11
B77446

Location

Loc Qty

Loc Code

ST433

3

72969

3

D2572

Manufactured No

110 Each

2.0000

1

1

D2572

Saddle, Fwd In 205

**

B 77246

Location

Loc Qty

Loc Code

ST433

2

71107

2

D2573

Manufactured No

110 Each

0.0000

1

1

D2573

Saddle, Aft Out 205

D2574

Manufactured No

110 Each

0.0000

1

1

D2574

Saddle, Aft In 205

D2876

Manufactured No

110 Each

23.0000

2

2

D2876

Saddle Spacer

**

**

**

B77287
B77286
B76949 12/11/11

Location

Loc Qty

Loc Code

ST025

23

72136

23

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 75903

75903

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

D2877

Manufactured No

110

Each

87.0000

2

D2877

Saddle Spacer

**

Location

Loc Qty

Loc Code

ST025

87

72135

21

73309

66

Manufactured No

110

Each

44.0000

8

D3403-1

D3403-1

Bushing

**

Location

Loc Qty

Loc Code

ST052

44

70696

15

75672

29

Manufactured No

110

Each

126.0000

4

D2747

D2747

Set Screw

**

Location

Loc Qty

Loc Code

ST021

126

71163

26

73495

100

Manufactured No

110

Each

84.0000

2

D3533-1

D3533-1

Set Screw

**

Location

Loc Qty

Loc Code

ST065

84

73310

84

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Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 75903

75903

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN4C6A

Purchased

No

110

Each

330.0000

16

16

AN4C6A

Bolt

**

Location

Loc Qty

Loc Code

FG

4

103344

4

ST356

326

116704

15

118451

11

118983

100

119328

200

AN4C52A

Purchased

No

110

Each

61.0000

4

4

AN4C52A

BOLT

**

Location

Loc Qty

Loc Code

ST361

61

117163

8

117688

7

118451

46

AN6C12A

Purchased

No

110

Each

16.0000

8

8

AN6C12A

BOLT

**

Location

Loc Qty

Loc Code

ST341

16

118422

16

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 75903

75903

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3672-3 Manufactured No 110 Each 691.0000 32

D3672-3

Phenolic Washer

**

Location

Loc Qty

Loc Code

ST074

691

64176

180

72230

11

73487

500

AN960C416L Purchased No 110 Each 0.0000 32

***AN960C416L ***

WASHER

**

D3672-9 Manufactured No 110 Each 232.0000 8

D3672-9

Phenolic Washer

**

Location

Loc Qty

Loc Code

ST074

232

35523

232

NAS1149C0632R Purchased No 110 Each 88.0000 8

***NAS1149C0632R ***

WASHER

**

Location

Loc Qty

Loc Code

ST297

88

118006

88

D3672-11 Manufactured No 110 Each 99.0000 8

D3672-11

Phenolic Washer

**

Location

Loc Qty

Loc Code

ST074

99

58046

99

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 75903

75903

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

1,105.000

29

MS21043-4

**

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1065

117793

65

118686

500

119309

500

D3403-3

Manufactured

No

110

Each

13.0000

8

D3403-3

**

Bushing

Location

Loc Qty

Loc Code

ST

3

69509

3

ST052

10

71852

10

D3405-041

Manufactured

No

110

Each

12.0000

1

D3405-041

**

Lug Assembly

Location

Loc Qty

Loc Code

ST474

12

62227

2

73338

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 75903

75903

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3405-043

Manufactured No

110

Each

6.0000

1

1

D3405-043

Lug Assembly

**

B 76999

Location

Loc Qty

Loc Code

ST423

2

65703

2

ST478

4

73339

4

AN4C47A

Purchased

No

110

Each

57.0000

4

4

AN4C47A

Bolt

**

Location

Loc Qty

Loc Code

ST361

57

117163

7

118451

50

D3407-041

Manufactured

No

110

Each

25.0000

1

1

D3407-041

Tow Ring

**

B 76223

Location

Loc Qty

Loc Code

ST463

25

75029

25

D3417-3

Manufactured

No

110

Each

60.0000

2

2

D3417-3

Washer

**

12/1/12

Location

Loc Qty

Loc Code

FG

9

33519

9

ST053

51

51648

4

53182

23

66847

24

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 75903

75903

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

D3456-1

Manufactured No

110

Each

96.0000

1

D3456-1

Washer

**

Location

Loc Qty

Loc Code

FG

7

25701

7

ST054

89

66848

3

71165

2

73493

84

AN3C37A

Purchased

No

110

Each

132.0000

1

AN3C37A

BOLT

**

Location

Loc Qty

Loc Code

ST354

132

116874

11

117010

2

118518

44

118709

50

119324

25

AN3C40A

Purchased

No

110

Each

73.0000

1

AN3C40A

BOLT

**

Location

Loc Qty

Loc Code

ST354

73

112454

23

114442

50

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 75903

75903

Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN3C41A Purchased No 110 Each 98.0000 1 ******

AN3C41A

BOLT

Location	Loc Qty	Loc Code
FG	4	
103324	4	
ST354	94	
119035	44	
119324	50	

AN3C42A Purchased No 110 Each 38.0000 1 ******

AN3C42A

BOLT

Location	Loc Qty	Loc Code
ST354	38	
106176	1	
117763	17	
118131	20	

AN3C43A Purchased No 110 Each 38.0000 4 ******

AN3C43A

BOLT

Location	Loc Qty	Loc Code
ST354	38	
114455	13	
118387	25	

AN3C46A Purchased No 110 Each 47.0000 5 ******

AN3C46A

BOLT

Location	Loc Qty	Loc Code
ST355	47	
118758	47	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 75903

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Parent Item: D412-742-013

D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 01/11/2011

Required Date: 15/11/2011

Start Qty: 1.00

Required Qty: 1.00

AN960C10L NAS1149C0332 Purchased

No

110

Each

0.0000

26

26

***AN960C10I ***

M119736

washer

MS21043-3

Purchased

No

110

Each

727.0000

13

13

MS21043-3

M119901

Nut

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

655

118077

1

118614

477

118686

177

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. D
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-742 REV. 3

REF. CANADIAN STC: SH05-37
REF. FAA STC: SR01583SE
REF. EASA STC: EASA.IM.R.S.01126

PURPOSE:

The purpose of this service instruction is to introduce an alternate wearplate installation for the D412-742-011/-013 Skidtube Installations. The new DSI-9517-011 Wearplate Kit consists of new wearplates destined to replace existing D3564-1/-3 Wearshoes and D3566-1/-3 Gaskets. The components in the DSI-9517-011 Wearplate Kit are as defined in the parts list on sheet 4 of this service instruction.

INSTALLATION PROCEDURE:

Replace D3564-1/-3 Wearshoes and D3566-1/-3 Gaskets with D4095-041/-043 Wearplates Assemblies as follows:

1. Remove existing D3564-1/-3 Wearshoes and D3566-1/-3 Gaskets per Item 32.6.1 of ICA-D412-742. It might be necessary to loosen the aft end of D3564-5 Wearshoe and D3566-5 Gasket.
2. Remove qty.(4) AN4C52A Bolts, D3403-1 Bushings, and qty.(8) D3672-11 Washers as indicated in Figures 1 and 2 of this service instruction.
3. Inspect the skidtube and saddles per Chapter 5 of ICA-D412-742.
4. Seal existing inserts located on both sides of the skidtube in area shown in Figures 1 and 2 of this service instruction using Sikaflex -241/-291 or Proseal 890 or MIL-S-8802 Class 2B sealant.
5. Locate the DSI-9517-011 Wearplate Kit as shown in Figure 1 and 2 of this service instruction.
6. Transfer drill qty.(2) Ø0.438 hole from the skidtube/saddle to the D4095-041/-043 Wearplates Assemblies. Deburr. Touch up finish per Item 5.2.14 of ICA-D412-742 as required.
7. Install the DSI-9517-011 Wearplate Kit using the same AN3C hardware as shown in ICA-D412-742. Torque to 15-25 in-lbs (1.7-2.8 N-m).
8. Install D3403-5 Bushings and AN4C53A Bolts in lieu of D3403-1 Bushings and AN4C52A Bolts removed at step 2 above. Ensure that the nuts on the AN4C Bolts are on the inboard side of the skidtube. Torque to 50-70 in-lbs (5.7-7.9 N-m).
9. Amend weight and balance per the Weight and Balance Table below.

WEIGHT AND BALANCE:

Use the following weight and balance information for DART D412-742-011/-013 skidtube and saddle installations equipped with DSI-9517-011 Wearplate Kit.

INSTALLATION	WEIGHT	LATERAL		LONGITUDINAL	
		ARM	MOMENT	ARM	MOMENT
D412-742-011 <i>Float Skidtube Installation with DSI-9517-011 Kit Installed</i>	70.0 lb 31.8 kg	±55.0 in ±1.40 m	±3850 in-lb ±44.5 m-kg	130 in 3.3 m	9100 in-lb 105 m-kg
D412-742-013 <i>Float Skidtube Installation with DSI-9517-011 Kit Installed</i>	70.0 lb 31.8 kg	±55.0 in ±1.40 m	±3850 in-lb ±44.5 m-kg	130 in 3.3 m	9100 in-lb 105 m-kg

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CONTROLLED COPY
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WORK ORDER
75903 M.C.J.

11/11/01

B	ITEM 21B AND 22B REMOVED FROM PARTS LIST		XDF	11.10.11
A	NEW ISSUE		MB	10.04.21
REV.	DESCRIPTION		BY	DATE
DESIGN	J	DART AEROSPACE USA, INC KENT, WA		
DRAWN	XDF			
CHECKED	J	DRAWING NO.		REV. B
MFG. APPR.	N/A	DSI 9517		SHEET 1 OF 6
APPROVED	140	TITLE		SCALE
DE APPR.	-H	ALTERNATE WEARPLATE KIT		NTS
DATE	11.10.11	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

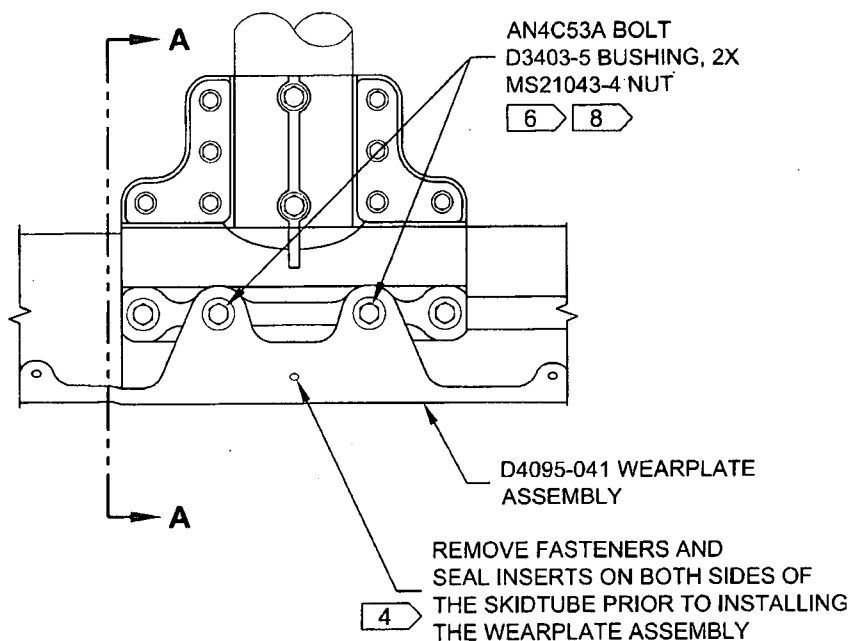
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

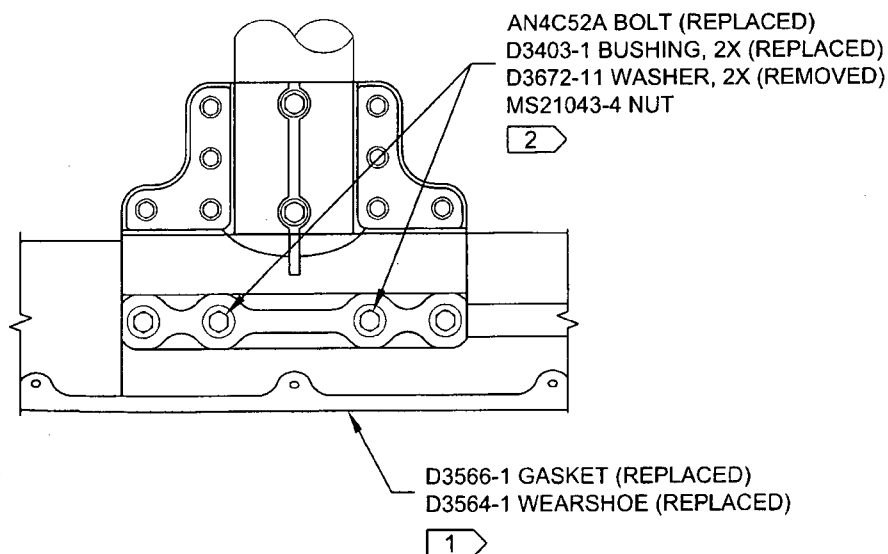
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

IS:



WAS:



**FIGURE 1: CHANGE AT FORWARD SADDLE LOCATION
WITH DSI-9517-011 KIT INSTALLED**

DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9517	SHEET 2 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

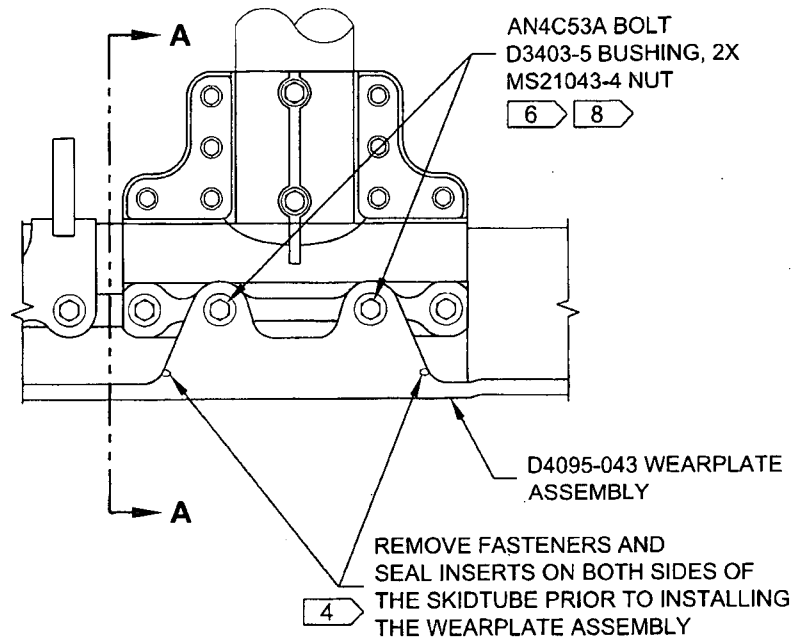
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

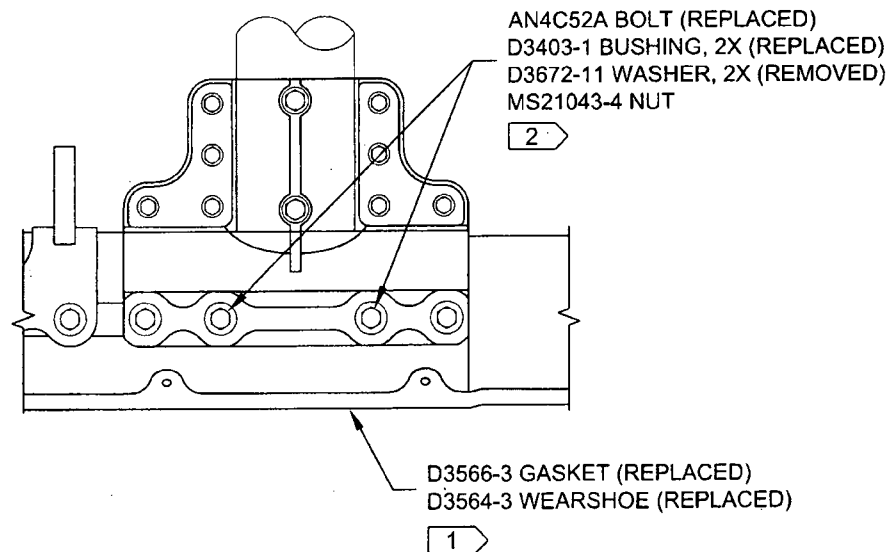
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

IS:



WAS:



**FIGURE 2: CHANGE AT AFT SADDLE LOCATION
WITH DSI-9517-011 KIT INSTALLED**

DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9517	SHEET 3 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ALTERNATE WEARPLATE KIT	NTS
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25603

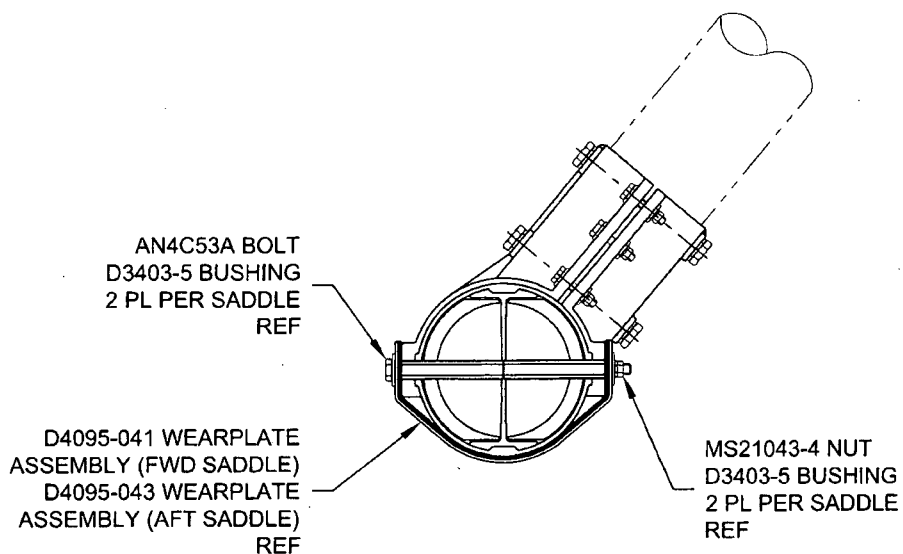
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION A-A

DSI-9517-011 PARTS LIST:

QTY -011	PART NUMBER	DESCRIPTION
X	DSI-9517-011	WEARPLATE KIT
8	D3403-5	BUSHING
1	D4095-041	WEARPLATE ASSEMBLY
1	D4095-043	WEARPLATE ASSEMBLY
4	AN4C53A	BOLT

DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9517	SHEET 4 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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75507

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

THE PARTS LISTS IN SECTION 32.15 OF ICA-D412-742 (PAGES 53 AND 55) AND SECTION 5.1 OF IIN-D412-742 (PAGES 16 AND 17) ARE AMENDED AS FOLLOWS WHEN OPTIONAL DSI-9517-011 KIT IS INSTALLED:

32.15 D412-742-011 (PMA/OEM) FLOAT SKIDTUBE INSTALLATION PARTS LIST (ICA-D412-742)
5.1 D412-742-011 (PMA/OEM) FLOAT SKIDTUBE INSTALLATION PARTS LIST (IIN-D412-742)

Item	QTY -011	QTY -041	QTY -015	PART NUMBER	DESCRIPTION
	X			D412-742-011	FLOAT SKIDTUBE INSTALLATION
	1	X		D412-742-041	FLOAT SKIDTUBE
	1		X	D412-742-015	ELECTRIC STEP KIT

IS:

3		10		AN3C6A	BOLT (REMOVED QTY.2)
4		4		AN3C7A	BOLT (REMOVED QTY.4)
5		38		AN960C10L	WASHER (REMOVED QTY.6)
21A		1		D4095-041	WEARPLATE ASSEMBLY
22A		1		D4095-043	WEARPLATE ASSEMBLY
46	8			D3403-1	BUSHING (REPLACED QTY.4 WITH D3403-5)
46A	8			D3403-5	BUSHING (REPLACES QTY.4 D3403-1)
49	4			AN4C52A	BOLT (REPLACED QTY.4 WITH AN4C53A)
49A	4			AN4C53A	BOLT (REPLACES QTY.4 AN4C52A)
53	8			D3672-11	WASHER (REMOVED QTY.8)

WAS:

3		12		AN3C6A	BOLT
4		8		AN3C7A	BOLT
5		44		AN960C10L	WASHER
21A		1		D3564-1	WEARPLATE
21B		1		D3564-3	WEARPLATE
22A		1		D3566-1	GASKET
22B		1		D3566-3	GASKET
46	16			D3403-1	BUSHING
49	8			AN4C52A	BOLT
53	16			D3672-11	WASHER

DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9517	SHEET 5 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ALTERNATE WEARPLATE KIT	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

THE PARTS LISTS IN SECTION 32.16 OF ICA-D412-742 (PAGES 57 AND 59) AND SECTION 5.2 OF IIN-D412-742 (PAGES 18 AND 19) ARE AMENDED AS FOLLOWS WHEN OPTIONAL DSI-9517-011 KIT IS INSTALLED:

32.16 D412-742-013 (APICAL TRI-BAG) FLOAT SKIDTUBE INSTALLATION PARTS LIST (ICA-D412-742)
5.2 D412-742-013 (APICAL TRI-BAG) FLOAT SKIDTUBE INSTALLATION PARTS LIST (IIN-D412-742)

Item	QTY -013	QTY -043	PART NUMBER	DESCRIPTION
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043	FLOAT SKIDTUBE

IS:

3		10	AN3C6A	BOLT (REMOVED QTY.2)
4		4	AN3C7A	BOLT (REMOVED QTY.4)
5		38	AN960C10L	WASHER (REMOVED QTY.6)
21A	1		D4095-041	WEARPLATE ASSEMBLY
22A	1		D4095-043	WEARPLATE ASSEMBLY
46	8		D3403-1	BUSHING (REPLACED QTY.4 WITH D3403-5)
46A	8		D3403-5	BUSHING (REPLACES QTY.4 D3403-1)
49	4		AN4C52A	BOLT (REPLACED QTY.4 WITH AN4C53A)
49A	4		AN4C53A	BOLT (REPLACES QTY.4 AN4C52A)
53	8		D3672-11	WASHER (REMOVED QTY.8)

WAS:

3		12	AN3C6A	BOLT
4		8	AN3C7A	BOLT
5		44	AN960C10L	WASHER
21A		1	D3564-1	WEARPLATE
21B		1	D3564-3	WEARPLATE
22A		1	D3566-1	GASKET
22B		1	D3566-3	GASKET
46	16		D3403-1	BUSHING
49	8		AN4C52A	BOLT
53	16		D3672-11	WASHER

DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC	
DRAWN	XDF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9517	SHEET 6 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ALTERNATE WEARPLATE KIT	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries